

Date: Wednesday, 12/7/2005 8:26:08 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CONSOLE SIDE LH (206 HI-SLOPE)
<b>Job Number</b> : 25140	
<b>Estimate Number</b> : 11000	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D26021
<b>This Issue</b> : 12/7/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2602 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 1/10/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : SEE COMMENT BELOW	
<b>Comment</b> : Est. D 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-2	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 1.4146 sf(s)/Unit    Total : 14.1456 sf(s)  
 2024-T3 .040 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040) Batch M19059

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Cut Blank per template DT8243

J.L 05.12.16 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA145 and Dwg D2602  
 Stack of 10  
 Identify as D2602-1

J.L 05.12.16 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05.12.16 10

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

E 05/12/16 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 22 Date: 06/10/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 25140

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SD 06/01/16 10

SAD 1/18/12/05 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-01-16 10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-19 10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

206-01-19 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA.

FF 06-01-24 10

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/01/24 (10)

DD 06/01/24

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25140
<b>Description:</b> Console Side LH/RH	<b>Part Number:</b>	D2602-1/-2
<b>Inspection Dwg:</b> D2602 <b>Rev:</b> A1		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

[illegible]

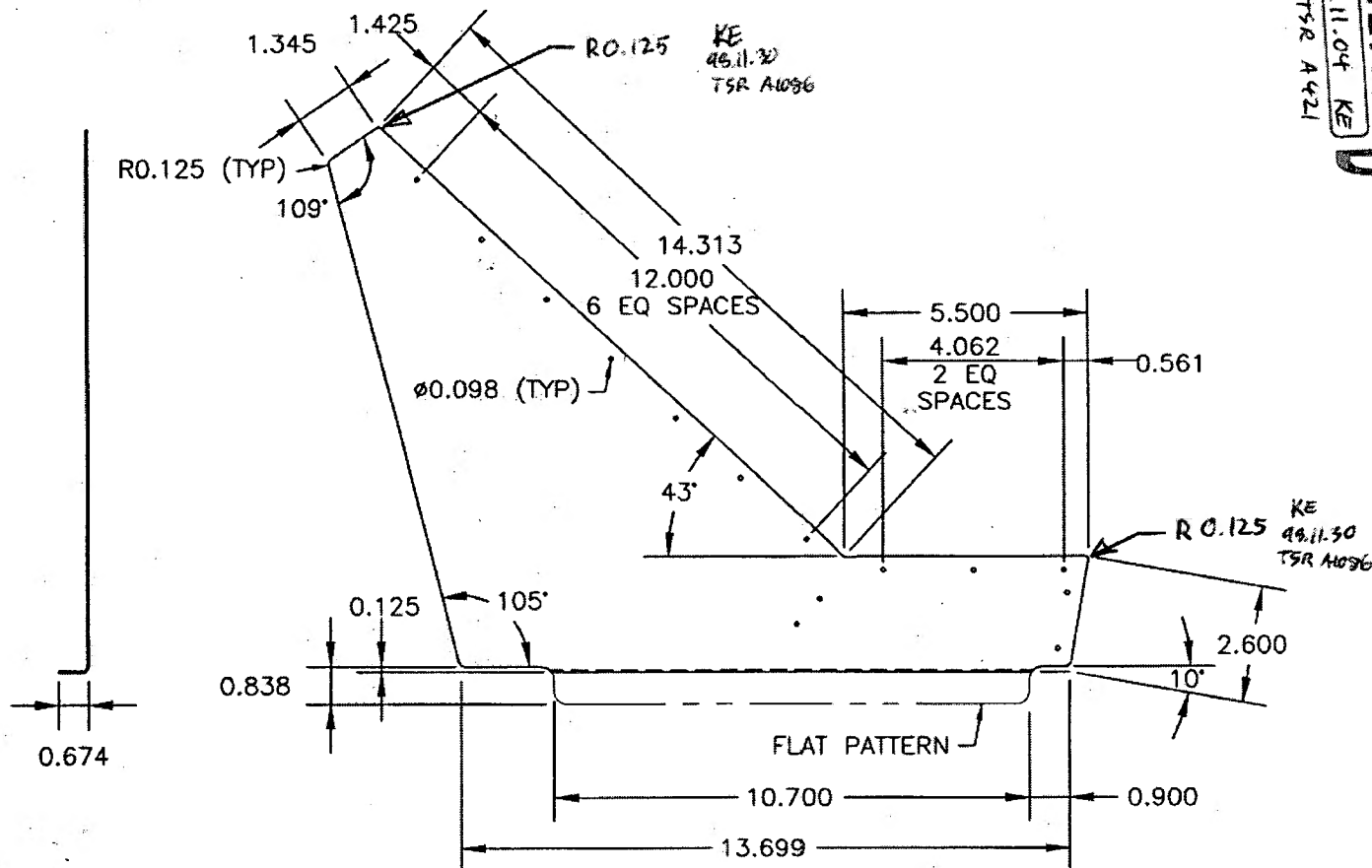
Measured by:	JL	Audited by:	Jml	Prototype Approval:	N/A
Date:	05-12-16	Date:	05/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	



RELEASED  
97.11.04 KE  
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED B.W.	DRAWING NO. D2602	REV. A
DATE 97.10.22		TITLE CONSOLE SIDE	SHEET 1 OF 1
			SCALE 1:4
A	97.10.22	D2602 WAS D206-547-21/-22	
AI	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
PROFILE CONTROLLED BY FOLIO H2602  
BEND RADIUS 0.093  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  $\Delta$  AI  
D2602-1 SHOWN  
D2602-2 OPPOSITE

RELEADED COPY  
10/10/2000  
OUT NOTICE  
25140